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DART AEROSPACE LTD	Work Order:	24297
Description: Arm	Part Number:	D2802-2
Dwg: D2802 rev.A	Qty:	6

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	LI	05.09.15	6
2	METAL	Cut blanks <u>15.800"</u> long <u>17.800"</u> Material: 6061-T6 bar 6.00" x 0.50" Batch: <u>M18463</u>	JL	05.08.15	6
3	HAAS	Machine as per folio FA101	SN	05.09.20	6
4	CNC-CELL	Counter sink .375 dia as per dwg	3G	05.09.21	6
5	QC	Inspect Level 2	SN	05.09.20	6
6	QC	Inspect Level 8	JG	05/09/25	6
7	METAL	Tumble & Deburr NO sharp edges.	Tml	05/09/27	6
8	QC	Inspect Level 5	Tml	05/09/27	6
9	FINISHING	Chemical conversion coat as per QSI 005 4.3	N/A		
10	STORES	Identify and stock	AD	05.09.27	6
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: <u>44.34</u> <u>545</u> <u>05/09/29</u> <u>(6)</u> <u>48.42</u>	<u>(19)</u>	<u>05/09/28</u>	<u>6</u>




Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	02.03.18	Re-format	NG	02-03-18

RELEASED

02/03/18

PTO

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	2	Change Blank Size.	JMA			 05-09-27	 05-09-27
05-09-27	9	Parts going directly from CNC to welding onto steps D412-630-014	PD	05-09-27	6		 05-09-27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.09.19	3	- 1 part scrap did not machine the full profile - error on work order	Q5142	- scrap and replace	J.L	18 0509-27	Q5142	18 0509-27
05.09.19	3	Pivot hole is 0.588" when machined	CP 05.09.19	OK to machine hole 0.587 ^{+0.001} _{-0.001}	Q5142 05/09/27	Q5142	CP 05.09.19 per Q5142	18 0509.27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/09/28

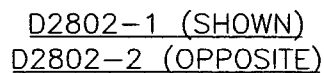
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

GA COPY ISSUED

DESIGN <i>CH</i>		DRAWN BY <i>CH</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CH</i>	DRAWING NO. D2802		'REV. A SHEET 1 OF 1	
DATE 00.11.03		TITLE ARM		SCALE 1:3	
A	00.11.03	NEW ISSUE			

00-11-13



MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SUBJECT TO AMENDMENT
WITHOUT NOTICE

ORDER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 15, 2005
10:56 am

Work Order No : 0024297
Project Name : D2802-2
Project For : WK539
Work Order Type : Main
Main WO Number :
House Part Number : D2802-2
Description : Arm
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 09-15-05
Est Finish Date : 09-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24297
Description: ASM		Part Number: D2802
Inspection Dwg: D2802	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	± .010	.501	✓			
5.030	± .010	.030	✓			
Ø.191	± .005 - .001	.192	✓			
5.541	± .010	5.551	✓			
5.125		.125	✓			
1.500	± .010	1.500	✓			
.100	± .010	.101	✓			
Ø.507	± .004 - .001	.508	✓			
2.033	± .010	2.033	✓			
.250	± .010	.250	✓			
1.000	± .010	1.000	✓			
2.000	± .010	2.001	✓			
1.347	± .010	1.347	✓			
Ø.507 ± .001	± .001	.508	✓			
.250 deep	± .010	.249	✓			
14.776	± .010	14.776	✓			
.125	± .010	.132	✓			
.500	± .010	.501	✓			
Ø.375 x 100°	± .010	.375	✓			

Measured by: J.L.	Audited by: EP	Prototype Approval:
Date: 05.09.19	Date: 05/09/19	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Chris Provencal

From: "David Shepherd" <davids@dartaero.com>
To: "Chris Provencal" <chrisp@dartaero.com>
Sent: September 19, 2005 5:19 PM
Subject: Re: D2802-1/-2

This is an acceptable deviation. I think it would be a good idea to update the drawing as you proposed for all future parts.

David

----- Original Message -----

From: Chris Provencal
To: David Shepherd
Sent: Monday, September 19, 2005 3:04 PM
Subject: D2802-1/-2

They are machining D2802-1/-2 arms. The pivot hole is now 0.507+0/-0.001. They are getting 0.508. The tool program is cutting 0.507 and it's ending up 0.508. They'd have to get Jean-Luc to change the program (not here now). Would a dimension of 0.507+0.001/- 0.001 be allowable?

Sincerely,

Chris Provencal

***DART* Aerospace Ltd.**

Email...chrisp@dartaero.com

Phone...613-632-3336

Fax.....613-632-4443

19/09/2005